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Friday, 9/15/2006 11:53:05 AM Kim Johnston User:, **Process Sheet Drawing Name** : GHW MEDIUM BELL Customer : CU-DAR001 Dart Helicopters Services Job Number : 28607A **Estimate Number** : 12 729 : D412729041 **Part Number** : NIA P.O. Number : DSK 092 REV B **Drawing Number** 9/15/2006 This Issue : N/A **Project Number** Prsht Rev. : MACHINED PARTS : B **Drawing Revision** First Issue : N/A : 28606A Material **Previous Run Due Date** : 10/15/2006 Qty: Written By Checked & Approved By LPS3 rust inhibitor added; Hardware P/N's Comment changed KJ/JLM **Additional Product** Job Number: Description: Seq. #: Machine Or Operation: DOCUMENT CONTROL DC 1.0 Comment: DOCUMENT CONTROL 06-09.19 Kg If D412-729-041 is a W/O on it's own, Photocopy bluefile and create labels per PPP D412-729-041 CHG003 2.0 D27287 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Comment: Qtv.: Pick: Qty Part Number Description Batch 1 D2728-7 Label <u>B22554</u> D3233041 Wheel Assembly 3.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Pick: **Qty Part Number** Description Batch 2 D3233-041 Wheel Assembly

Inside Washer

D32331 4.0

Comment: Qty.:

2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch 2 D3233-1 Inside Washer 32840

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Friday, 9/15/2006 11:53:05 AM Date: User: Kim Johnston **Process Sheet** Drawing Name: GHW MEDIUM BELL Customer: CU-DAR001 Dart Helicopters Services Part Number: D412729041 Job Number: 28607A Job Number: Seq. #: **Machine Or Operation:** Description: D32333 Outside Washer 5.0 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Comment: Qtv.: Pick: Description Batch B2861-U **Qty Part Number** 2 D3233-3 Outside Washer Col 07.01-27 D33091 6.0 Each(s)/Unit Total: #.0000 Each(s) Comment: Qty.: 1,000 Pick: **Qty Part Number** Description Batch 1 D3309-1 Label \$277-67 D33093 7.0 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Comment: Qty.: Pick: **Qty Part Number** Description Batch 2 D3309-3 Label **B23768** 8.0 D3330041 Frame Weldment Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: Qty Part Number Description Batch
1 D3330-041 Frame Weldment 328614 D3331041 9.0 Handle Assembly Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: Qty Part Number Description
1 D3331-041 Handle Assembly

Batch

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Friday, 9/15/2006 11:53:05 AM Date: Kim Johnston User: **Process Sheet** Drawing Name: GHW MEDIUM BELL Customer: CU-DAR001 Dart Helicopters Services Part Number: D412729041 Job Number: 28607A Job Number: Seq. #: Machine Or Operation: Description: D3332041 Pin Assembly 10.0 2.0000 Each(s) Comment: Qtv.: 1.0000 Each(s)/Unit Total: Pick: Oty Part Number Description Batch
1 D3332-041 Long Pin Assembly 32770 CAL 07.01-27 D3332043 Pin Assembly 11.0 Comment: Qtv.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: Description Batch **Qty Part Number** 1 D3332-043 Short Pin Assembly 10 D33331 12.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: Description _ Batch **Qtv Part Number** 1 D3333-1 Base Plate **328615** pc 07.01.27 · D33333 Sliding Plate 13.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Pick: Description Batch Qty Part Number Sliding Plate <u>B28616</u> 1 D3333-3 14.0 D33335 Comment: Qty.: 4,0000 Each(s)/Unit Total: 8.0000 Each(s) Pick: Description Batch Qty Part Number 4 D3333-5 Rail B28617 _ DL 07.01.27

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Friday, 9/15/2006 11:53:05 AM Date: Kim Johnston User: **Process Sheet** Drawing Name: GHW MEDIUM BELL Customer: CU-DAR001 Dart Helicopters Services Job Number: 28607A Part Number: D412729041 Job Number: Seq. #: **Machine Or Operation:** Description: Wheel Shaft D33341 15.0 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Comment: Qty.: Pick: **Qty Part Number** Description Batch GC 07.01.27 2 D3334-1 Wheel Shaft D33351 16.0 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Comment: Qty.: Pick: Description Batch **Qty Part Number** 1 D3335-1 Short Spring 322256 G1 07.01.77 17.0 D33353 Long Spring Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: Qty Part Number Description Batch
1 D3335-3 Long Spring B22256 GC 07.01-27 18.0 D33361 1.0000 Each(s)/Unit Total: Comment: Qty.: 2.0000 Each(s) Pick: Qty Part Number Description Batch
1 D3336-1 Jack \$\sqrt{323772B}\$ \$\mathrm{323023B}\$

AN960JD416 19.0



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Description Batch Qty Part Number 2 AN960JD416 Washer <u>M 101939</u> Col 07.01.27

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Friday, 9/15/2006 11:53:06 AM Date: User: Kim Johnston **Process Sheet** Drawing Name: GHW MEDIUM BELL Customer: CU-DAR001 Dart Helicopters Services Part Number: D412729041 Job Number: 28607A Job Number: Description: Seq. #: **Machine Or Operation:** 1/8" Cotter Pin 2" long 20.0 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Comment: Qty.: Pick: Qty Part Number Description Batch 2 CP-21 1/8" Cotter Pin 2" long, Span 21.0 2.0000 Each(s) 1.0000 Each(s)/Unit Total: Comment: Qty.: Pick: Description Batch Qty Part Number 1 HC-12 1/4"-20 UNC x 1" long Hex Bolt, Span m16529 HC29 5/16-18 UNCx1.5 Hex Bolt 22.0 Comment: Qty.: 16.0000 Each(s)/Unit Total: 32.0000 Each(s) Pick: Description Batch Qty Part Number 16 7-29 5/16"-18 UNC x 1.5" long Hex Bolt, Prof M 103/65 Ppc 07-01-27 3/8"-24UNFx1.25 Hex Bolt Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s) Pick: **Qtv Part Number** Description Batch 8 1533/8"-24 UNF x 1.25" long Hex Bolt, Span 24.0 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Comment: Qty.: Pick: Description Batch Qty Part Number 2 HN-1201" Slotted Nut, Prof <u>M102150</u> Col 07:01.27

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Friday, 9/15/2006 11:53:06 AM Date: Kim Johnston User: **Process Sheet** Drawing Name: GHW MEDIUM BELL Customer: CU-DAR001 Dart Helicopters Services Job Number: 28607A Part Number: D412729041 Job Number: Description: Seq. #: Machine Or Operation: 5/16-18UNC Nylon LockNut 25.0 HN177 16.0000 Each(s)/Unit Total: 32.0000 Each(s) Comment: Qty.: Pick: Description Batch Qty Part Number 16 HN-1775/16"-18 UNC Nylon Lock Nut, Span MIOZISO COC 07.01.27 1/4-20 UNCx3/4 S.H.C.S. HX15 26.0 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Comment: Qty.: Pick: Description Batch Qty Part Number CPL 07.01.27 Nut 27.0 MS21042L5 Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Pick: ---Description Batch Qty Part Number Cg(07.01.27 2 MS21042L5 Nut (or -5) M10217/ 1 1/4" Type B Washer 2333 28.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: Qty Part Number Description Batch 1 2333 1 1/4" Type B Flat Washer (Wide), Span MoZIGO CPC 07.01.27 3/8" Lock Washer 18SNB 29.0

Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s)
Pick:

Qty Part Number Description Batch 8 18-SNB3/8" Lock Washer, Span M19705

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Friday, 9/15/2006 11:53:06 AM Date: Kim Johnston User: **Process Sheet** Drawing Name: GHW MEDIUM BELL Customer: CU-DAR001 Dart Helicopters Services Part Number: D412729041 Job Number: 28607A Job Number: Description: Seq. #: **Machine Or Operation:** 1/8" PTF Grease Fitting 113803 30.0 _4.0000 Each(s) Comment: Qty.: 2.0000 Each(s)/Unit Total: Pick: 2 113-803 1/8" PTF Grease Fitting, Span M19705 - 4 * Cpl 07:01-27

16WC SS Flat Washer 5/16 **Qty Part Number** Description Batch 31.0 516WC Comment: Qty.: 16.0000 Each(s)/Unit Total: 32.0000 Each(s) Pick: **Description Batch Qty Part Number** 16 5/16"WC Type B Flat Washer (Narrow), Prof M 10 3/65 Cpl 07.01.27 LARGE FABRICATION RESOURCE 1 LARGE FAB 1 32.0 No7.01.27 Comment: LARGE FABRICATION RESOURCE 1 Assemble as per Dwg DSK 092. Apply LPS3 heavy duty rust inhibitor & corrosion (Procyon). Inflate wheel assembly to 90 psi. Ensure that unit goes up and down smoothly after assembly. Install decals last. INSPECT WORK TO CURRENT STEP 33.0 QC5 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 PACKAGING 1 34.0 Comment: PACKAGING RESOURCE #1 Identify and Stock トヘト・スタ&っつ Location: 35.0 Comment: FINAL IN Job Completion U 07.02.13

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 А	0	4.12.06	NEW ISSUE				
В	05.02.18		REDESIGN TO FIT NEW WHEEL ASS'Y				

06 **D3330-17 HANDLE** D3309-1 HEX BOLT 1/4"-20'x 1" LONG (1) FLAT WASHER 1/4" TYPE B WIDE (1) SOCKET (1) LABEL (1) D3331-041 D2728-7 HANDLE ASS'Y (1 D3330-9 TOP LABEL (1) PLATE (1) HEX. SOCKET CAP SCREW 1/4"-20 x 0.75", D3330-5 FRONT PANEL (1) D3330-7 BACK PANEL (1) (NOT SHOWN, SIMILAR TO D3330-5) AN960JD416 **FLAT WASHER** D3330-15 HANDLE (1)-(2 PLACES) D3309-3 LABEL D3233-041 (2 PLACES) WHEEL ASS'Y D3333-3 SLIDING PLATE (2 PLACES) (2 PLACES) D3335-3 LONG D3330-11 LONG PIN SPRING (1) (NOT SHOWN) BRACKET (1) D3332-041 LONG PIN ASS'Y (1) D (D) **D3233-1 INSIDE** 0 WASHER (2 PLACES) D3233-3 OUTSIDE WASHER (2 PLACES) 0 0 D3336-1 JACK (1) SLOTTED NUT 0 1"-14 UNF AND 0 D3333-1 BASE **ROUND COTTER** PLATE (1) PIN 1/8" x 2" LONG (2 PLACES) (3) D3330-19 HANDLE RIM (1) D3334-1 WHEEL SHAFT (2 PLACES) Q D3330-3 **BOTTOM** PANEL (1) D3333-5 RAIL (4 PLACES) D3330-1 HEX. BOLT 3/8"-24 UNF x 1.25" LONG REG. SPRING LOCK WASHER 3/8" LEFT PANEL (1) D3332-043 (8 PLACES) SHORT PIN (1) D3330-2 HEX. BOLT 5/16"-18 UNC x 1.50" LONG FLAT WASHER TYPE B NARROW 5/16" RIGHT D3335-1 SHORT COPY-SPRING (1) HOP COPY PANEL (1) STD. HEX. NYLON LOCK NUT 5/16"-18 UNC (NOT SHOWN) URN TO (16 PLACES) D3330-13 MS21042L5 NUTENGINEERING SHORT PIN (2 PLACES) NCONTROLLED COPY **GREASE FITTING 1/8" P.T.F** BRACKET (1) SAE SPEC. EXTRA SHORT SUBJECT TO AMENDMENT (4 PLACES)

NOTE:

WITHOUT NOTICE 1) APPLY RUST INHIBITOR ON ALL PARTS AND AREAS NOT PROTECTED BY PAINT OR GREASE. WORK ORDER RUST INHIBITOR POSSIBLE SUPPLIER: ACKLANDS-GRANGER INC., P/N LPSC30316.

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